

shp Oct. 25

Work Order ID 91384

October-05-12 11:36:20 AM

91384

Page 1

Item ID: D4410-15 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rear Cover
Start Date: 10/05/12 Start Qty: 1200 *12* Cust Item ID:
Required Date: 10/12/12 Req'd Qty: 1200 *12* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12-10-05 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4410 | REV B | | | | | | | | |

100 0.00

100

Waterjet Memo 0.00 (16) 12-10-11

FLOW CNC Waterjet

6061 .100

CUT AS PER DWG
DWG REV: B
PROG REV: B

DEBURR

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00 (16) 12-10-11

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="width: 30%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="width: 30%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="width: 10%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 91384

91384

Page 2

October-05-12 11:36:20 AM

Item ID: D4410-15 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rear Cover
 Start Date: 10/05/12 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 10/12/12 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|-----------------|--------------|---------------|---------------|------------------|-----------------------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | Smb 12-10-12 | | 16 | | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: S/D Packaging Memo | 0.00 0.00 | | | | 16x | | | S 12-10-12. |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 12/10/12 UMF 12-10-12 |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Picklist Print

October-05-12 11:36:19 AM

Page 1

Work Order ID: 91384

Parent Item: D4410-15

Parent Item Name: Rear Cover

Start Date: 10/05/12

Required Date: 10/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 12/08/13 JFS VERIFY BY: JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.100 6061-T6 .100 Sheet | | Purchased | No | | | 100 | sf | 50.4000 | 0.008 | 0.1010532 | 1.5 | 12-10-11 | |

Location

Loc Qty

Loc Code

MAT021

50.4

102201

0.5

118072

5.6

118523

44.3

118523

16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

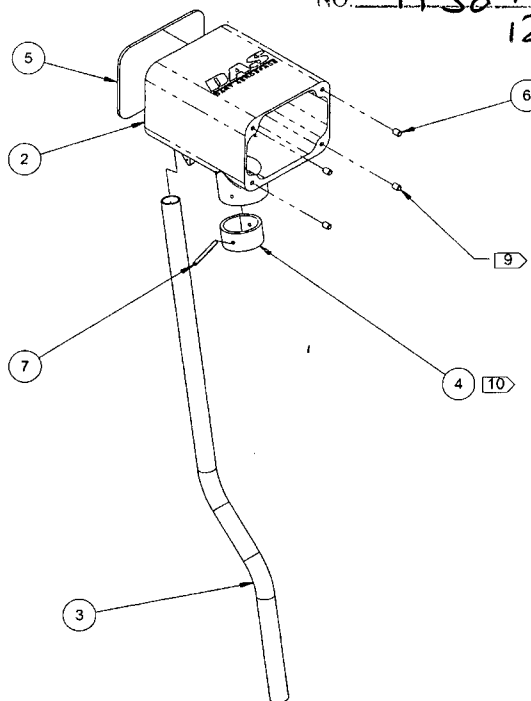
QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
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| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

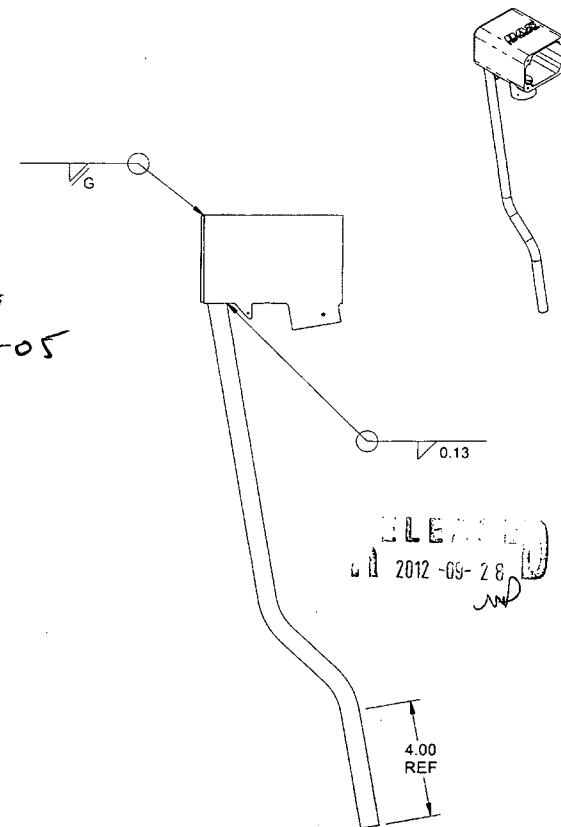
| FAULT CATEGORY | | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|---|
| 1 | X | D4410-041 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (205) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-11 | 205 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 7 | 1 | MS171539 | PIN |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91384 MJS
12-10-05



D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



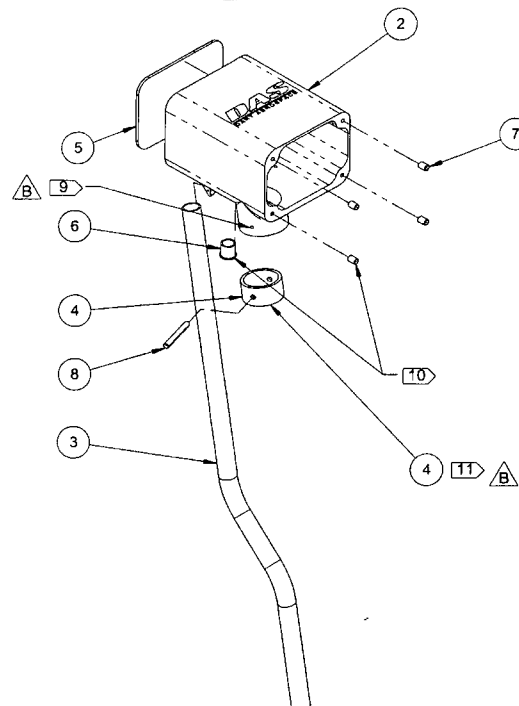
**D4410-041 WELDING DETAIL
(-041 SHOWN, -043/-045 SIMILAR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

| | | | |
|------------|--|---|---------------|
| B | ADD C'BORE, ZN A4-2, ENLARGE HOLES, ZN C5-3 & B8-3, UPDATE LOGO, ADD -045/-11/-13/-15, ROTATE HOLE, ZN C3-2, INCREASE -7 DIAMETER, ZN C1-6, REMOVE -8 FROM -041 ASSEMBLY, ZN C5-1. | DC | 12.07.30 |
| A | NEW ISSUE | DC | 11.06.06 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DC | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | DC | | |
| CHECKED | DC | DRAWING NO. | REV. B |
| MFG. APPR. | DC | D4410 | SHEET 1 OF 12 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| ITEM NO. | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|---|
| 1 | X | D4410-043 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (212) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-13 | 212 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 1 | D4413-1 | DOME PLUG |
| 7 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 8 | 1 | MS171599 | PIN |



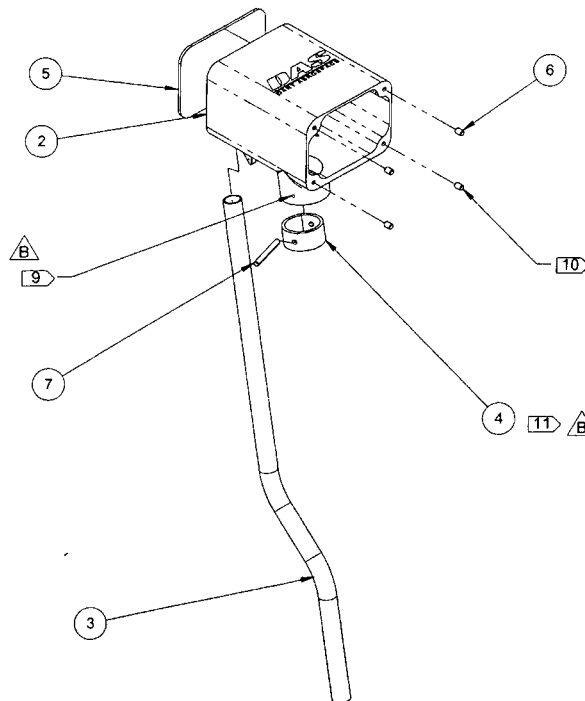
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

| | | | |
|------------|----------|---|---------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | AS | DRAWING NO. | REV. B |
| MFG. APPR. | 2/1 | D4410 | SHEET 2 OF 12 |
| APPROVED | 1/2 | TITLE | SCALE |
| DE APPR. | 1/2 | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | <small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| ITEM NO. | QTY. -045 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|--|
| 1 | X | D4410-045 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-13 | 212 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 7 | 1 | MS171599 | PIN |



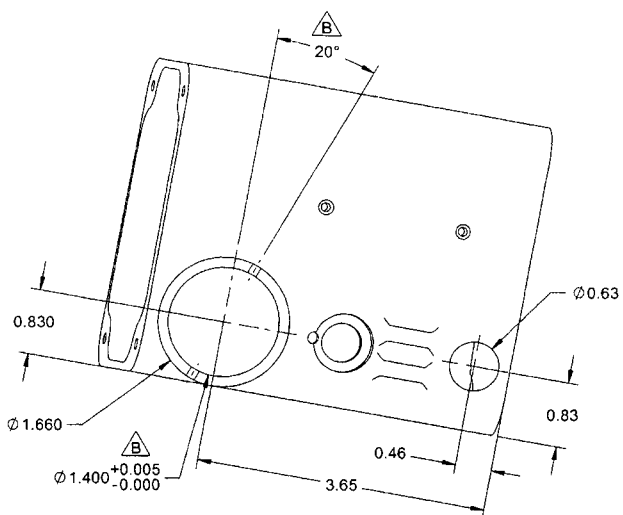
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

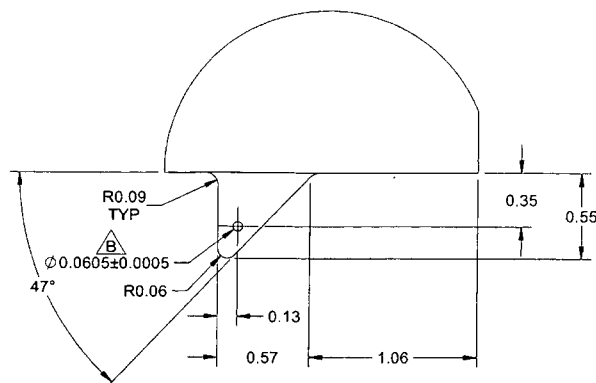
D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)

| | | | |
|---|----------|--|---------------|
| DESIGN | DL | DART AEROSPACE USA, INC. | |
| DRAWN | DL | KENT, WA | |
| CHECKED | DL | DRAWING NO. | REV. B |
| MFG. APPR. | DL | D4410 | SHEET 3 OF 12 |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | CO-PILOT COLLECTIVE HEAD NTS | |
| DATE | 12.07.30 | COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. | |
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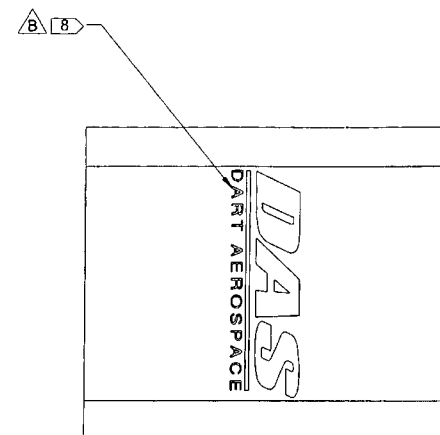
91384



VIEW A-A
C5-4



DETAIL B
C4-4



VIEW C-C
D4-4

**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

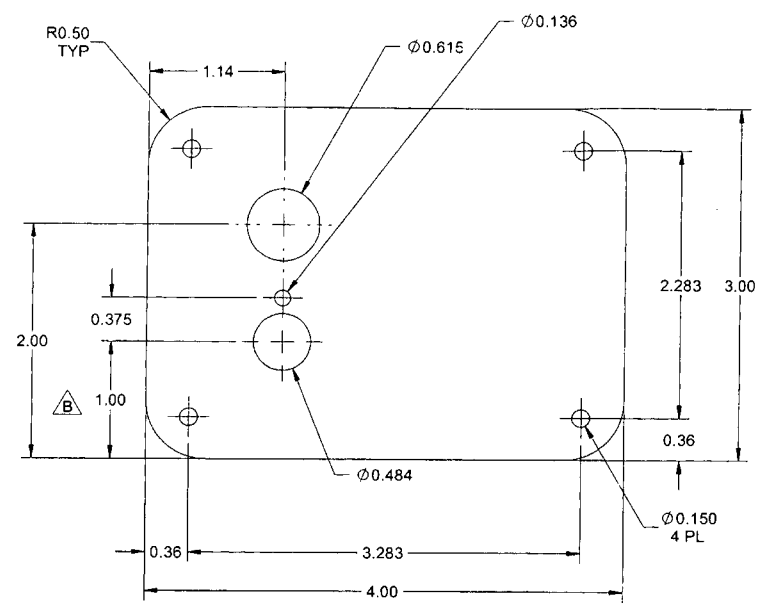
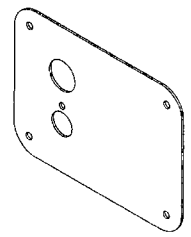
RELEASED
2012-09-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

| | | | |
|------------|----------|--|---------------|
| DESIGN | BC | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | BC | | |
| CHECKED | BC | DRAWING NO. | REV. B |
| MFG. APPR. | BC | D4410 | SHEET 5 OF 12 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | <small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

91384



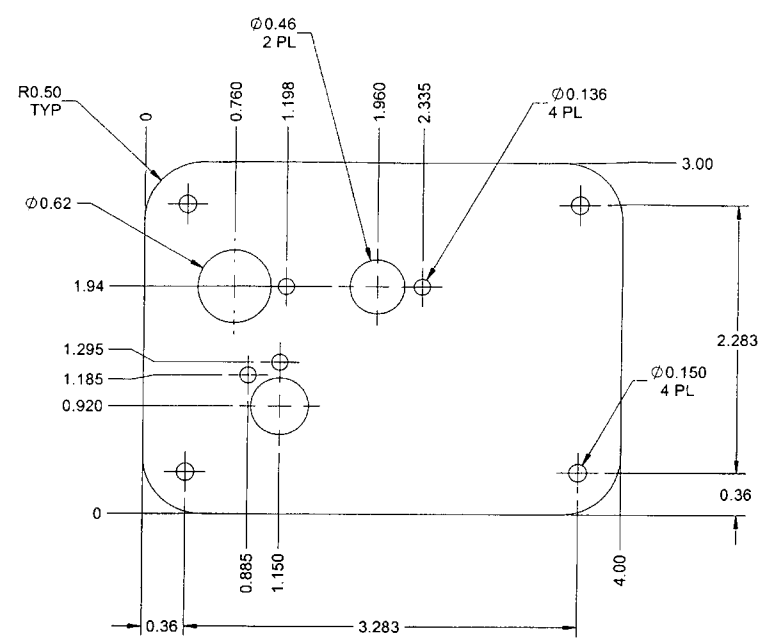
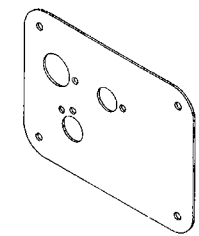
D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|--|---------------|
| DESIGN | DL | DART AEROSPACE USA, INC. | |
| DRAWN | DL | KENT, WA | |
| CHECKED | DL | DRAWING NO. | REV. B |
| MFG. APPR. | DL | D4410 | SHEET 6 OF 12 |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | CO-PILOT COLLECTIVE HEAD | NTS |
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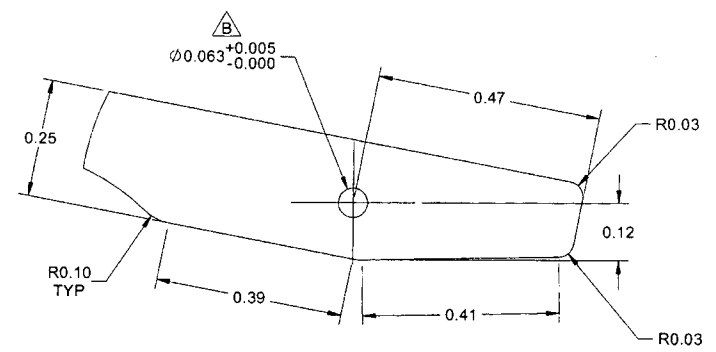
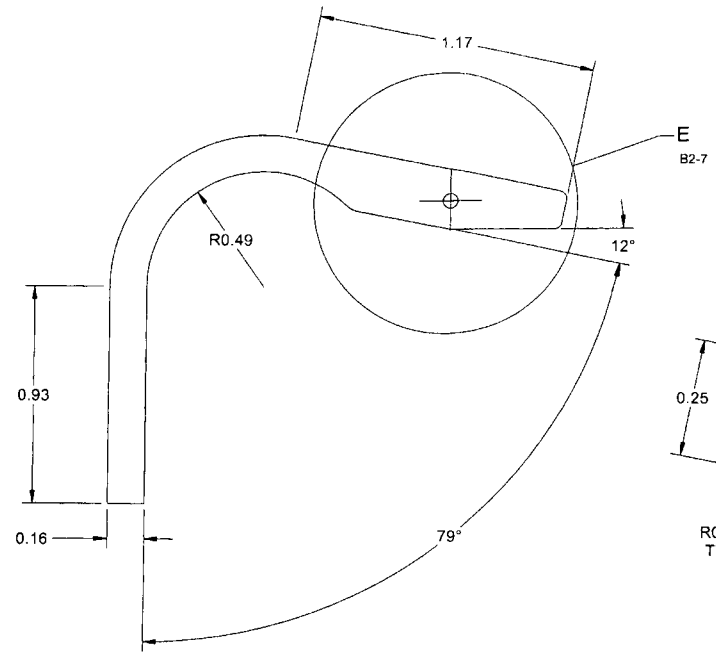
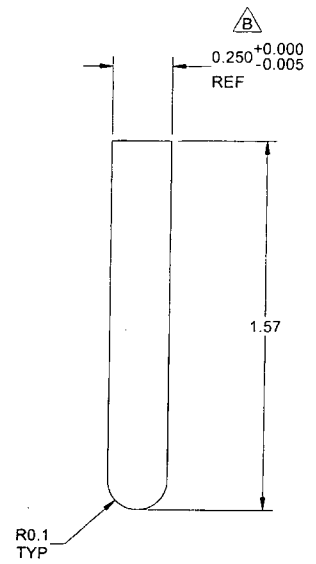
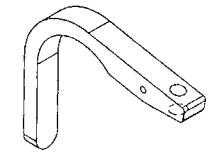
D4410-5 FACE PLATE

RELEASED
2012-09-28

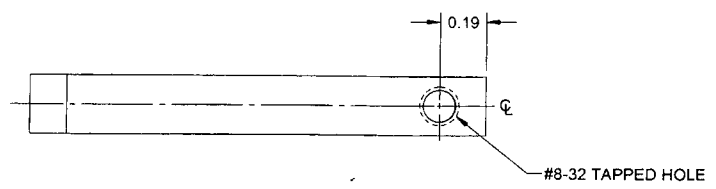
- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|---|--------|
| DESIGN | DL | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | DL | | |
| CHECKED | DL | DRAWING NO. D4410 | REV. B |
| MFG. APPR. | DL | SHEET 7 OF 12 | |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | <small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

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DETAIL E
D4-7



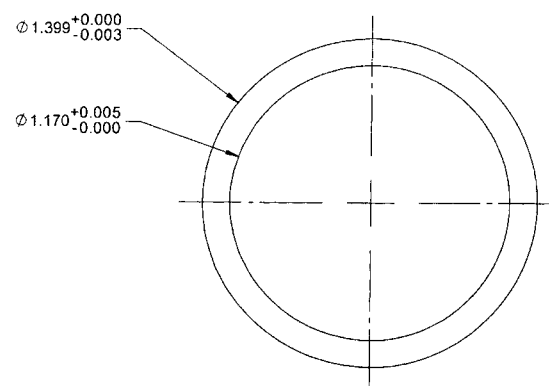
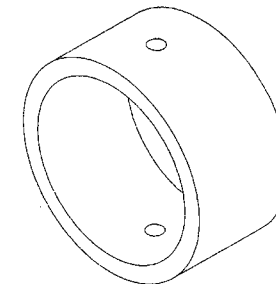
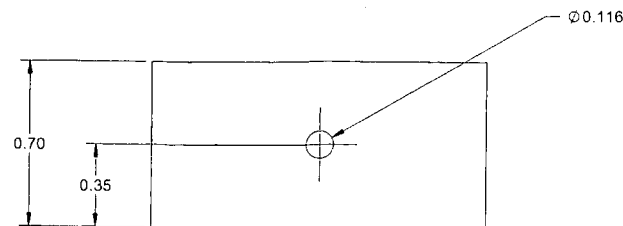
D4410-9 TRIGGER

RELEASED
2012-09-28
JAN

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

| | | | |
|------------|----------|---|---------------|
| DESIGN | BC | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | BC | | |
| CHECKED | BC | DRAWING NO. | REV. B |
| MFG. APPR. | BC | D4410 | SHEET 9 OF 12 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | CO-PILOT COLLECTIVE HEAD | NTS |
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D4410-11 205 SHIM

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2012-09-23
MD

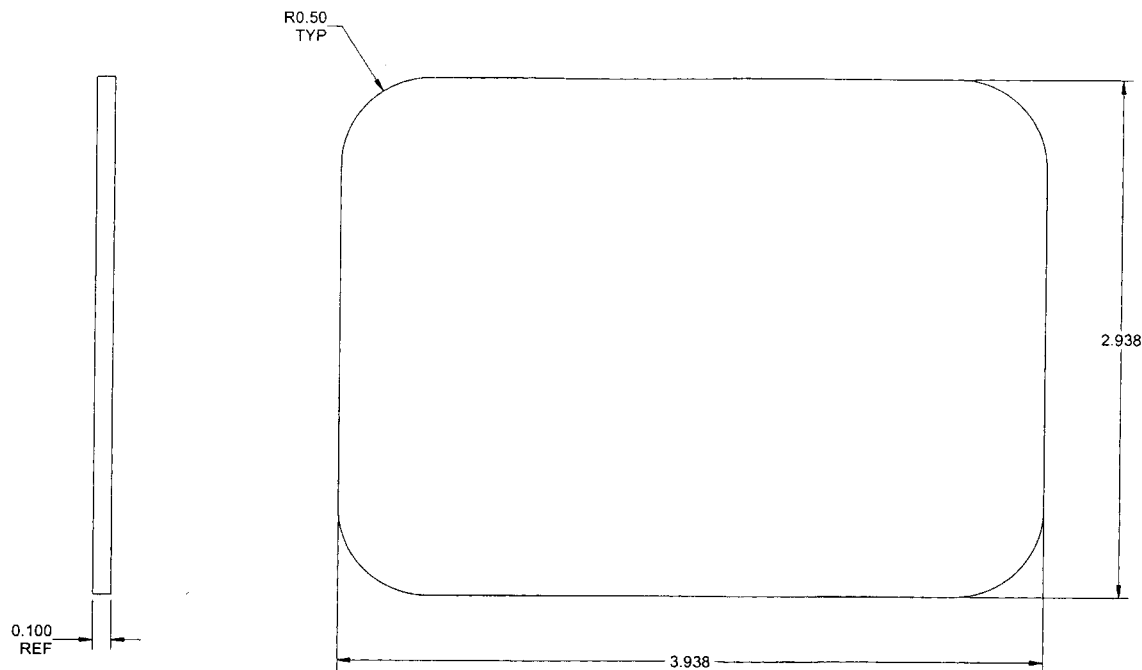
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|----------|---|--------|
| DESIGN | DC | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | DC | | |
| CHECKED | DC | DRAWING NO. D4410 | REV. B |
| MFG. APPR. | DC | SHEET 10 OF 12 | |
| APPROVED | MD | TITLE | SCALE |
| DE APPR. | MD | CO-PILOT COLLECTIVE HEAD | |
| DATE | 12.07.30 | NTS | |

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91384



D4410-15 REAR COVER

RELEASE
2012-09-28
JN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

| | | | |
|------------|----------|---|----------------|
| DESIGN | DC | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | BE | DRAWING NO. | REV. B |
| MFG. APPR. | JA | D4410 | SHEET 12 OF 12 |
| APPROVED | JA | TITLE | SCALE |
| DE APPR. | JA | CO-PILOT COLLECTIVE HEAD | NTS |
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